

Date: Tuesday, 4/24/2007 3:19:39 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLOWER MOTOR ADAPTER
Job Number	: 32042		
Estimate Number	: 12133	Part Number	: D3476043
P.O. Number	: <i>N/A</i>	Drawing Number	: D3476 REV A
This Issue	: 4/24/2007 S.O. No. : <i>N/A</i>	Project Number	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Material	: <i>N/A</i>
Previous Run	: 28565	Due Date	: 5/8/2007
Written By	:	Qty:	<i>1</i> Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-01-31 JLM		
	: est rev B added comment @ # 5.0 06.11.01 EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34763 DOME



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part Number Description Batch

1 D3476-3 blower motor adapter *B25689 -*

2.0 D34767 TUBE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty Part Number Description Batch

X 2 D3476-7 Tube *B32052*

3.0 D34761 duct



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty Part Number Description Batch

X 1 D3476-1 Duct *B32051*

4.0 NAS1031C3W Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number Description Batch

4 NAS-1031C3W Nutplate *M101462 -*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018

***** D3476-1 goes on top of D3476-3 *****

MF 07-05-01 *MF. 07-05-01* *(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/05/02

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:19:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 32042

Part Number: D3476043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

107-05-01 (1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107-05-01 (1)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

107-05-01 (1)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107-05-02 (1)

Job Completion



107-05-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

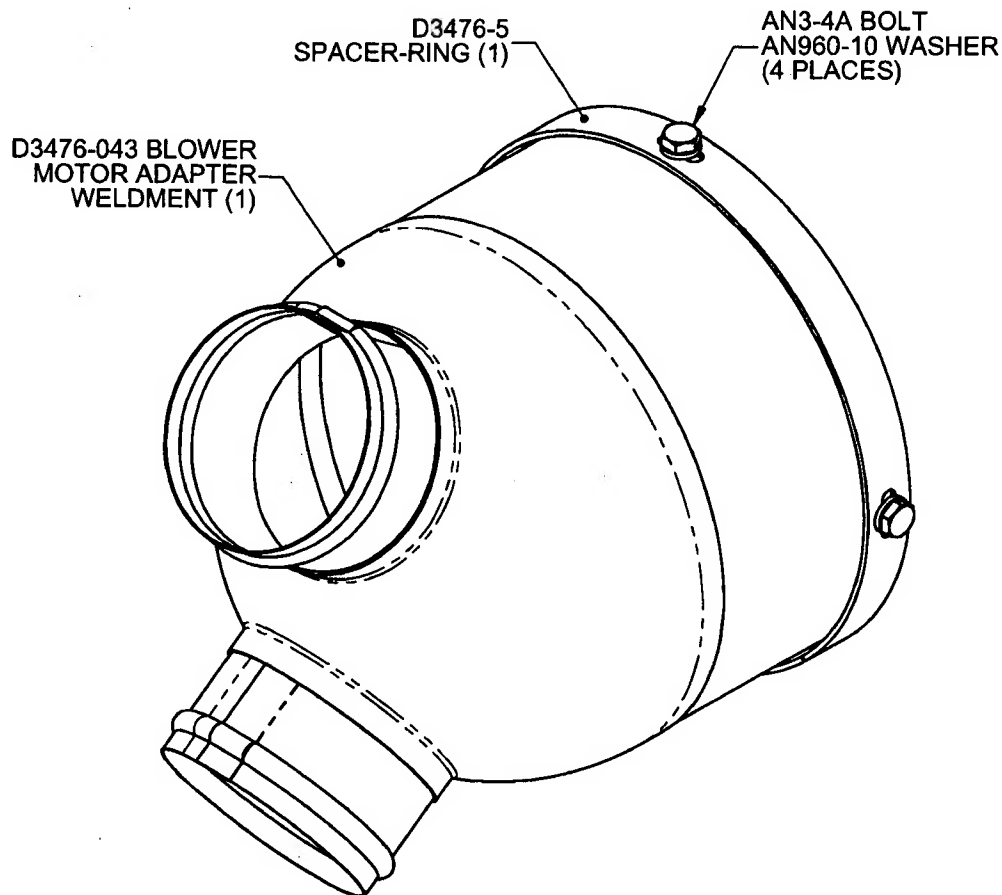
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:2	
A	06.01.27	NEW ISSUE	

[Signature] 06.04.03



D3476-041 BLOWER MOTOR ADAPTER

- 1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

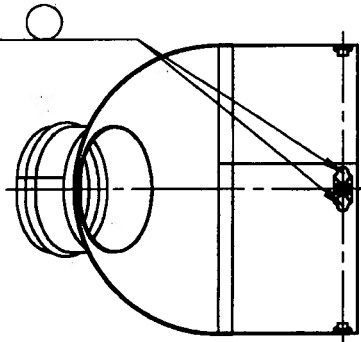
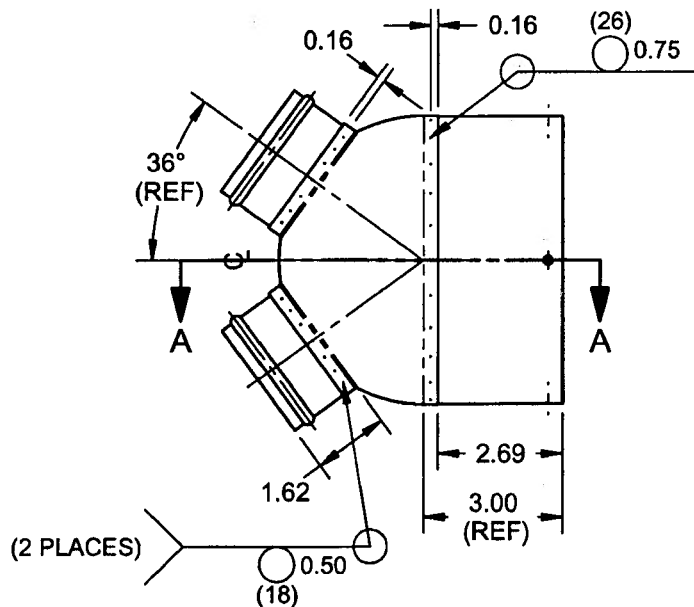
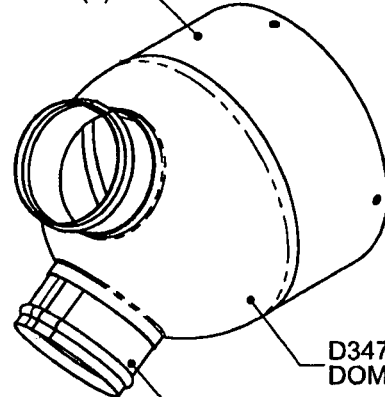
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)**SECTION A-A**D3476-1
DUCT (1)D3476-3
DOME (1)D3476-7 TUBE
(2 PLACES)NAS-1031C3W
NUT PLATES
(4 PLACES)OFFSET SEAM
ON DUCTSHOP COPY
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06-04-03

**D3476-043 BLOWER MOTOR
ADAPTER WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

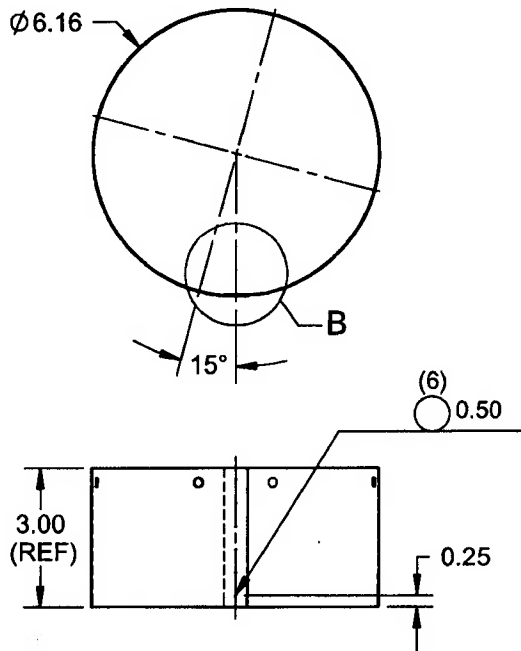
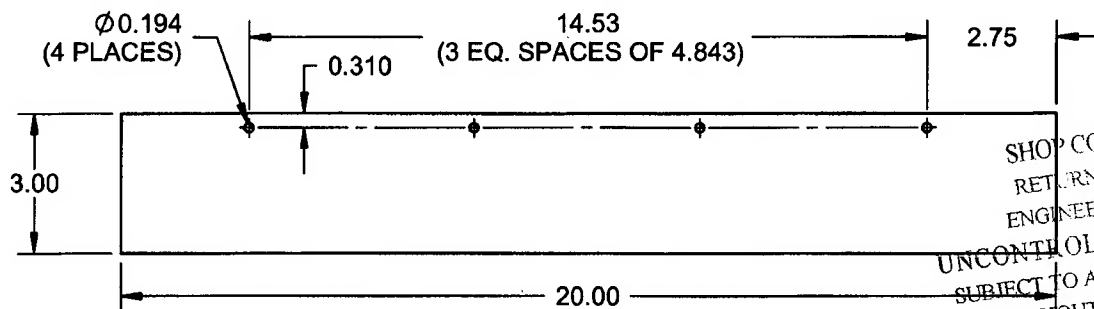
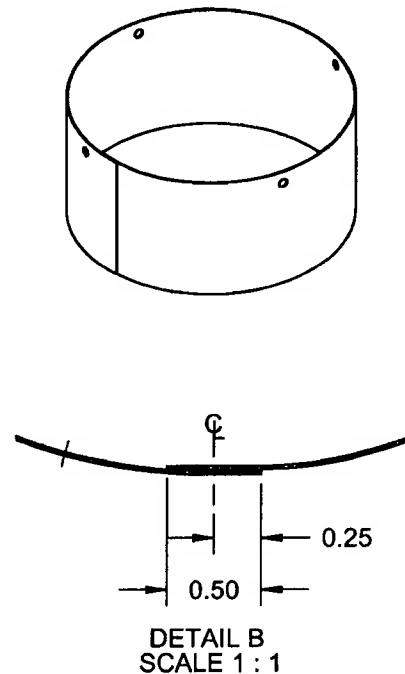
QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

06.01.03**D3476-1 DUCT****D3476-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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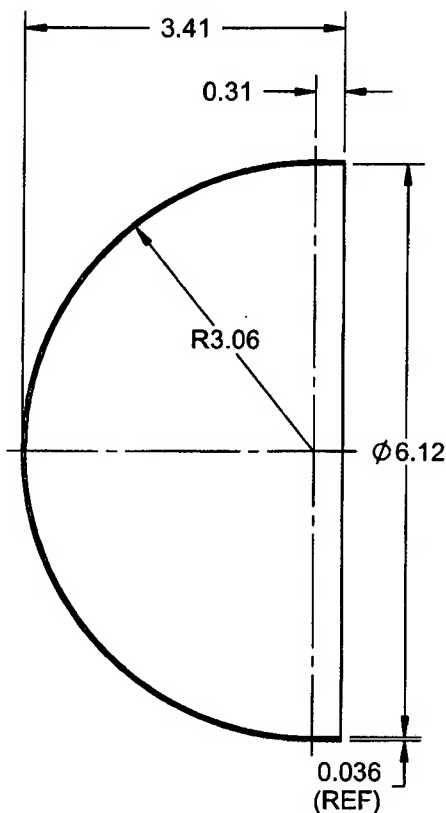
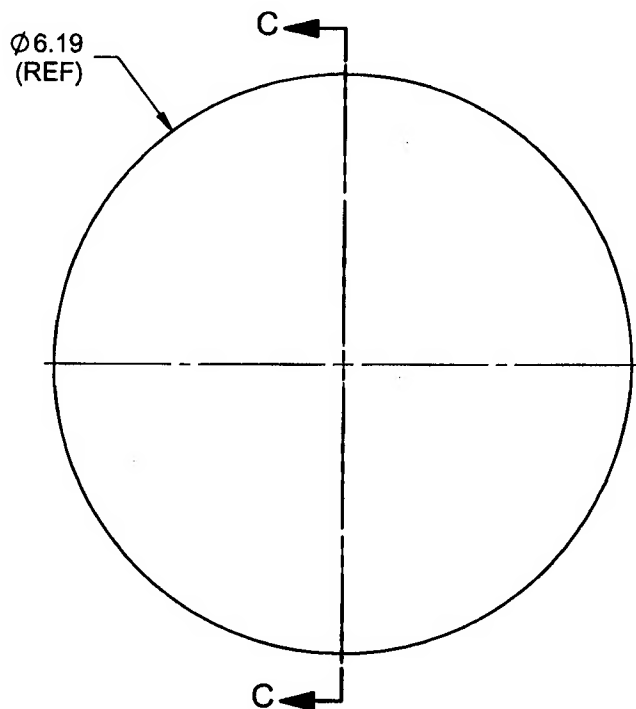
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

RELEASED
06.04.03 *[Signature]*



SECTION C-C

D3476-3S DOME, SPINNING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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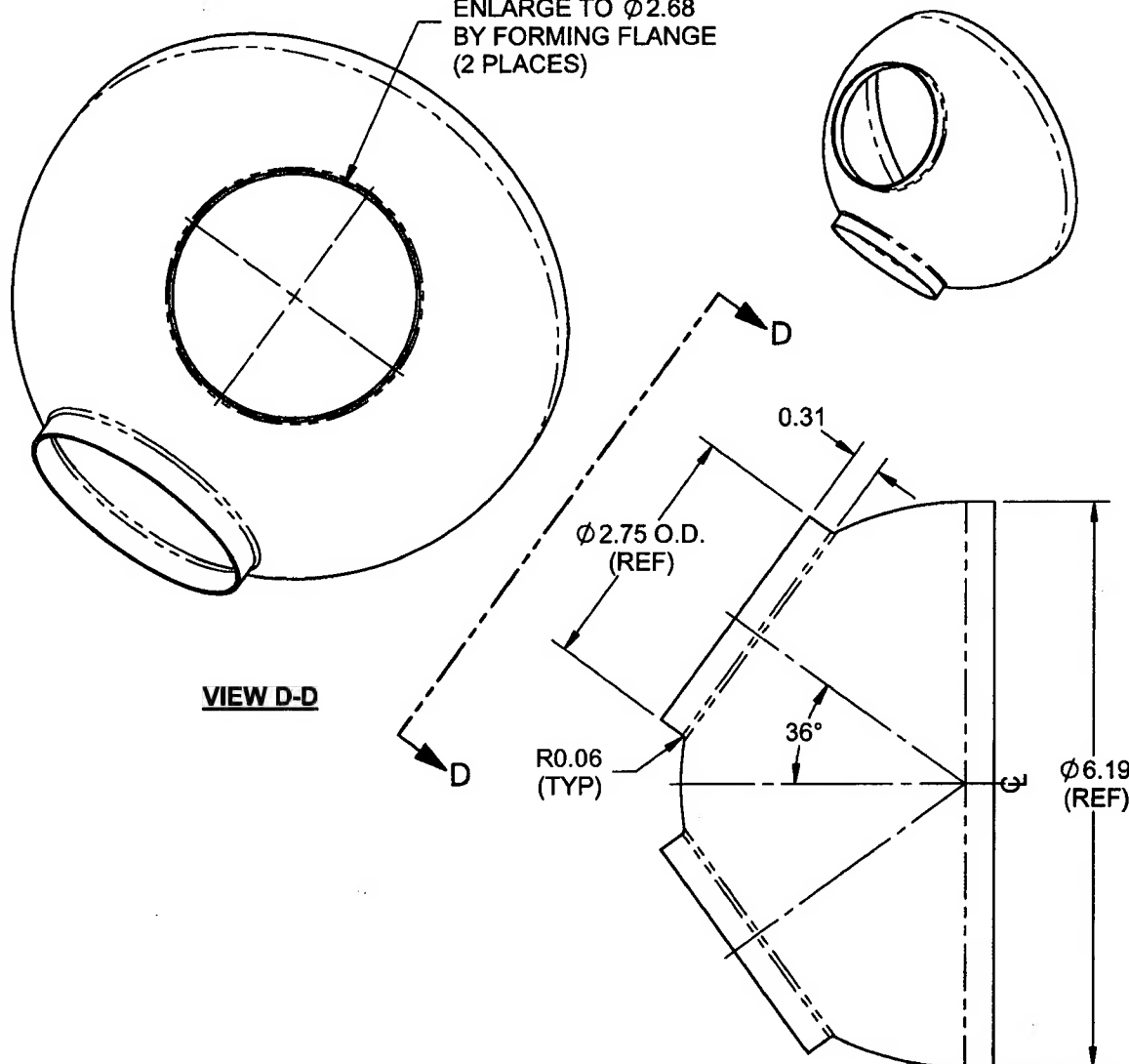
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

06.04.03

CUT $\phi 2.25$ HOLE,
ENLARGE TO $\phi 2.68$
BY FORMING FLANGE
(2 PLACES)



VIEW D-D

D3476-3 DOME

NOTES:

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

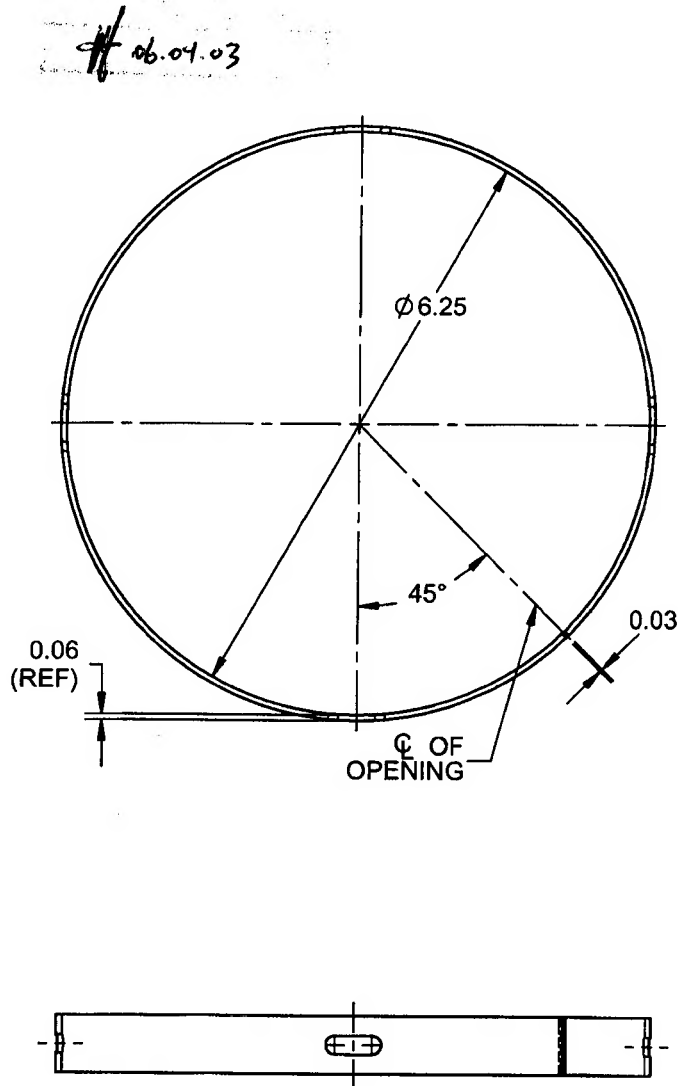
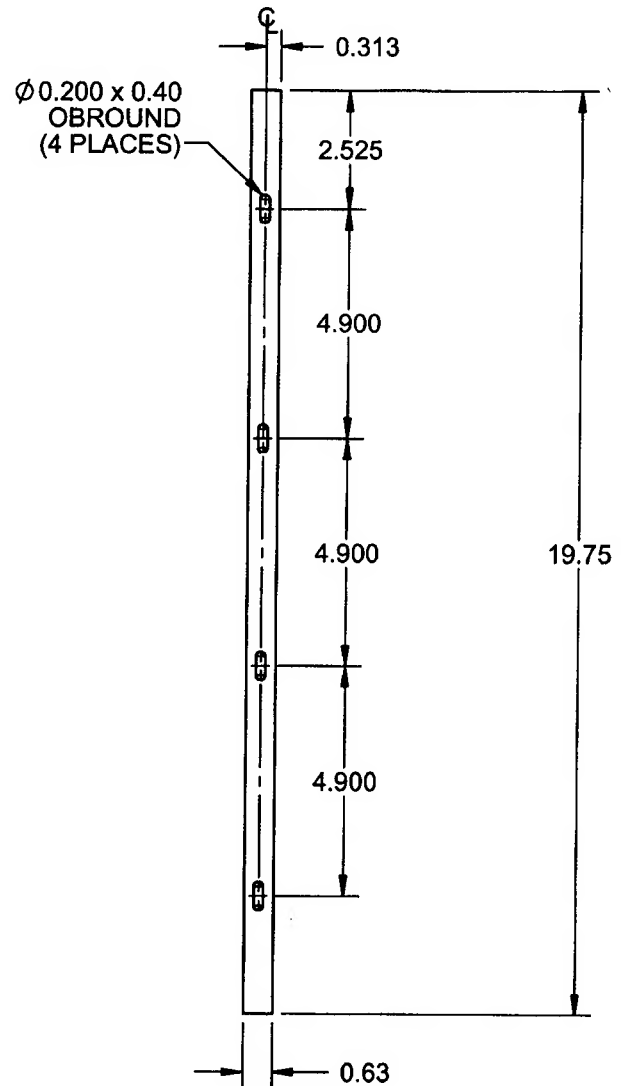
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DATE 06.01.27	TITLE BLOWER MOTOR ADAPTER		SCALE 1:2

**D3476-5 SPACER-RING****D3476-5F SPACER-RING**
FLAT PATTERN**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

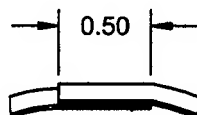
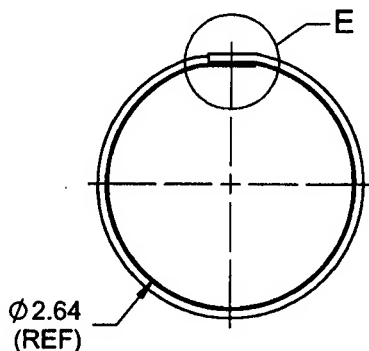
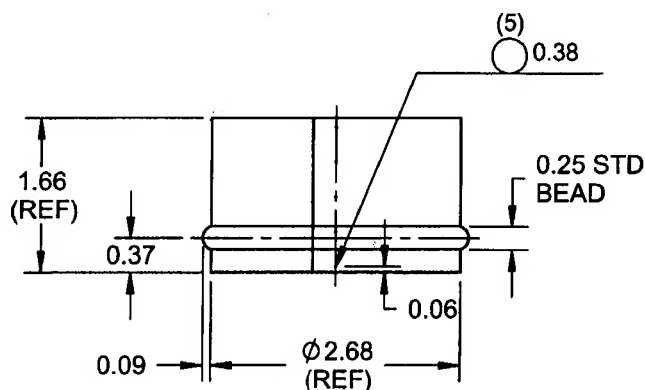
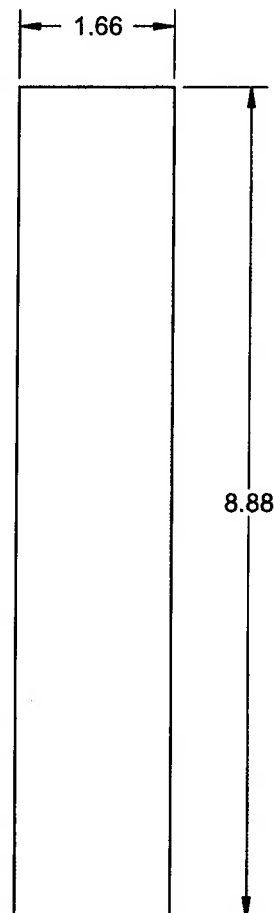
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

[Signature] 06.04.03DETAIL E
SCALE 1:1**D3476-7 TUBE****D3476-7 TUBE**
FLAT PATTERN**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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